



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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008955

D350-615-041
Job Sheet 192646



Part No: D350-615-041

Job Qty: 42 pcs

Part Name: GHW Modification, Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/28/19

Job Tracking No:

Due Date: 4/10/19

Created By: Shannon Hadley

Type: SOLD

Description:

Note: IIN REV B IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L revise bom DD 10.03.18 verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	42 pcs	4/10/19		0.00	3.87	Small Fab - 1		DAS 58 9-89 MAR 29 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	42 pcs	4/10/19		0.00	0.00	QC 5 - 10		DAS 40 9-89 APR 02 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 4 - 28		
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
130	QC 4	42 pcs	4/10/19		0.00	0.00	QC 4 - 46		DAS 46 9-89 APR 12 2019
							Packaging 3 - 1 - B4B		
140	Packaging 3-1 - Stock - B4B	42 pcs	4/10/19		0.00	0.00	Packaging 3 - 1 - B4B		

				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
145 DC - 1 - B4B	42 pcs	4/10/19	0.00 0.00	DC - 1 - B4B	DAS 21 APR 12 2019
				DC - 2 - B4B	9-89
150 QC 21 - FG	42 pcs	4/10/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	DAS 21 APR 12 2019
				QC 21 - FG - 53	9-89

Part Op 110 - Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C
 Descriptions: bolts***
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (QC4- 100% Inspect kits for completeness)
 140 - (Identify as per dwg & Stock Location: _____) Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 Location :FG023
 145 - Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
5/16-18-015C	SS Bolt 5/16-181.5"	126 Ea (3 ea)	110-Small Fab - 1	5156497
5/16WC	Washer	504 Ea (12 ea)	110-Small Fab - 1	8156551
7/16-14-050C	SS Bolt 7/16 5" Long	42 Ea (1 ea)	110-Small Fab - 1	5156553
7/16WC	Washer, SS Flat 7/16	84 Ea (2 ea)	110-Small Fab - 1	5156498
D2282-041	T Assembly	42 pcs (1 ea)	110-Small Fab - 1	5167668
D2282-043	Saddle Assembly	42 pcs (1 ea)	110-Small Fab - 1	5167668
D3015-3	Locknut	126 pcs (3 ea)	110-Small Fab - 1	5156557
D3015-5	SS Nylock Nut 7/16	42 pcs (1 ea)	110-Small Fab - 1	5131172

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	5/16-18-015C	126	652	0
	5/16WC	504	2,514	0
	7/16-14-050C	42	247	0
	7/16WC	84	504	0
	D2282-041	42	44	0
	D2282-043	42	45	0
	D3015-3	126	746	0
	D3015-5	42	307	0
Part Specifications				
Specifications could not be found.				

Plex 3/28/19 4:28 PM Dart.Hadley.Shannon



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D350-615-041
Job Sheet 189927



Part No: D350-615-041

Job Qty: 50 ea

Part Name: GHW Modification, Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 4/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN REV B IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L revise bom DD 10.03.18 verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		4/10/19	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	50 pcs		4/10/19	0.00	4.61	Small Fab-4		
120	QC	50 pcs		4/10/19	0.00	0.00	QC5		
130	QC	50 pcs		4/10/19	0.00	0.00	QC4		
140	Packaging	50 pcs		4/10/19	0.00	0.00	Packaging3-1		
145	DC	50 pcs		4/10/19	0.00	0.00	DC		
150	QC21-FG	50 Ea		4/10/19	0.00	0.00	QC21		

Part Op 110 - Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C Descriptions: bolts***

140 - Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 Location :FG023

145 - Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
5/16-18-015C	SS Bolt 5/16-181.5"	150 Ea (3 ea)	90-Start up Operation	
5/16WC	Washer	600 Ea (12 ea)	90-Start up Operation	
7/16-14-050C	SS Bolt 7/16 5" Long	50 Ea (1 ea)	90-Start up Operation	
7/16WC	Washer, SS Flat 7/16	100 Ea (2 ea)	90-Start up Operation	
D2282-041	T Assembly	50 pcs (1 ea)	90-Start up Operation	
D2282-043	Saddle Assembly	50 pcs (1 ea)	90-Start up Operation	
D3015-3	Locknut	150 pcs (3 ea)	90-Start up Operation	
D3015-5	SS Nylock Nut 7/16	50 pcs (1 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	5/16-18-015C	150	12	0
	5/16WC	600	567	0
	7/16-14-050C	50	97	0
	7/16WC	100	101	0
	D2282-041	50	2	0
	D2282-043	50	3	0
	D3015-3	150	149	0
	D3015-5	50	55	0
Part Specifications				
Specifications could not be found.				

Plex 2/1/19 7:34 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S168485



Part: D350-615-041

Job No: 192646

Serial No/Batch: S168485

Revision:

Inspector:

Exp Date:

Instructions: Certificate of Conformity only

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04/02/19